

Date: Wednesday, 6/28/2006 4:17:26 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BUSHING	
Job Number	: 27738		Part Number	: D26173	
Estimate Number	: 10308		Drawing Number	: D2617 REV D2	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 6/28/2006 S.O. No. : N/A		Drawing Revision	: D2	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 7/22/2006	
Previous Run	: 24400		Qty:	20	Um: Each
Written By	: <u>See comment below</u>		Comment	: Est G 04.07.14 Reformat; added step 5 KJ/JLM	
Checked & Approved By	: <u>KT 06 06 29 n</u>				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6T0375W058	6061-T6 Tube .375 x.058W	
		Comment: Qty.: 0.0765 f(s)/Unit Total : 1.5309 f(s) 6061-T6 Round Bar 1.5" Material : 6061-T6 (QQ-A-225/8 or QQ-A-200/8 or WW-T-700/6) Ø0.375" tubing x 0.058" wall (M6061T6T0.375W.058) Batch: <u>M19051</u>	
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		Comment: HARDINGE Turn as per Folio FA437 and Dwg D2617	 <i>N/A Machined Manually 06/07/19 22</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	 <i>06/07/19 22</i>
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	 <i>06/07/19 22</i>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr break all unmarked sharp edges 0.005 to 0.010	 <i>06/07/19 22</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

 NoDQA: 

Date: 06/07/24

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

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Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Acid etch and Alodine as per QSI 005 4.1

SAD 06/07/20 22

7.0 QC5

INSPECT WORK TO CURRENT STEP



Jan-07-21 22

Comment: INSPECT WORK TO CURRENT STEP

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST53

SL 06/07/21 22

9.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SL 06/07/21 22

Job Completion



SL 06.07.21

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector	
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	27738
Description: Bushing	Part Number:	D2617-3
Inspection Dwg: D2617 Rev: D2		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

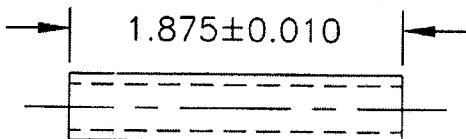
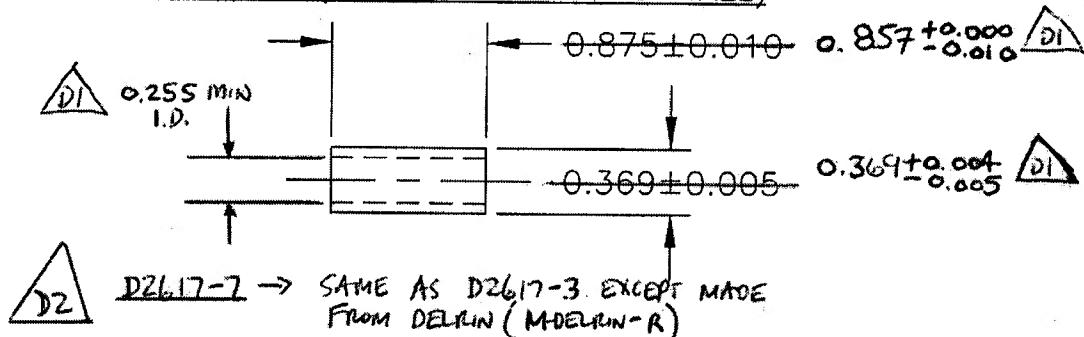
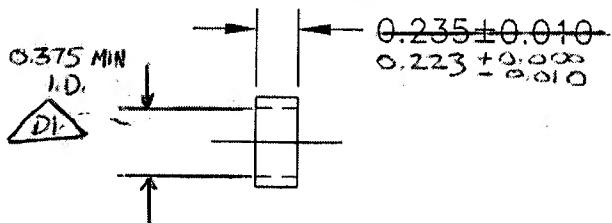
X First Article Prototype

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	06/07/19	Date:	06/07/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.09	New Issue	KJ/JLM	
B	06.03.08	Dwg Rev change	KJ/JLM	<i>[Signature]</i>

DART

DESIGN	BW	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO. D2617
DATE	01.07.04			REV. D SHEET 1 OF 1
				SCALE 1:1
D2 04.09.10 CP ADD D2617-7	A	96.10.08	TITLE BUSHING	
	B	97.05.08	.875 WAS 1.125	
	C	97.06.04	0.369 DIA WAS 0.375	
	D	01.07.04	ADD MAT'L SPEC AND TOL./DIM. NOTE	
	DI	04.07.12	CORRECT TOLERANCE (NCR 779)	

D2617-1 (0.375 OD x 0.058 WALL)D2617-3 (0.375 OD x 0.058 WALL)D2617-5 (0.500 OD x 0.058 WALL)
RELEASED
 01.07.05 CP
NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6) COPY
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED WORK ORDER
- 5) ALL DIMENSIONS ARE IN INCHES

NO. 27738

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RETURN TO

ENGINEERING

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

NO. 27738

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